

IN THE CLAIMS

Claims 1-49 were previously cancelled. Claims 50-98 are currently cancelled. New claims 99-116 are added, all as follows.

Claims 1-98 (Cancelled)

99. (New) A method for supplying rolls to a web-fed rotary printing press including:

- providing a roll supply system having at least a first subsystem embodied as a roll storage facility and having at least a second subsystem embodied as a roll transport system;

- providing a material flow system having a planning level and a coordination level; using said coordination level of said material flow system for controlling at least said roll transport system and for receiving stock data from said roll storage facility;

- providing a product planning system having production-relevant planning data regarding pending productions of said web-fed rotary printing press;

- providing actual production data in said web-fed rotary printing machine;

- transmitting said actual production data and said planning data to said material flow system;

- developing a supply strategy in said planning level of said material flow system using said actual production data, said planning data and said stock data; and

- using said supply strategy for supplying rolls to said web-fed rotary printing press from said roll storage facility of said roll supply system and using said roll transport system.

100. (New) The method of claim 99 further including providing a press management level in

said product planning system and further including a fixed signal connection for transmitting data between said press management level and said material flow system.

101. (New) The method of claim 99 including providing at least one fixed signal connection between said product planning system and said material flow system and transmitting data using said at least one fixed signal connection.

102. (New) The method of claim 99 further including providing a data network connecting said roll supply system, said material flow system and said product planning system of said web-fed rotary printing press.

103. (New) The method of claim 99 further including transmitting data between at least one of said subsystems of said roll supply system and said material flow system and using said data transmitted to said material flow system for controlling said at least one subsystem of said roll supply system.

104. (New) The method of claim 102 further including using said data network for transmitting data from said web-fed rotary printing press and said product planning system to said material flow system and for transmitting data from said material flow system to at least one of said subsystems in said roll supply system.

105. (New) The method of claim 99 further including providing planned production in said production-relevant planning data.

106. (New) The method of claim 99 further including transmitting at least one of an identification of a product, a roll circumference, a time and a location of use of a planned product to said material supply system.

107. (New) The method of claim 99 further including transmitting information regarding actual status of a running production of said web-fed rotary printing press as said production-relevant planning data.

108. (New) The method of claim 107 further including transmitting identification of said running production and an assignment of said running production to a roll change of said web-fed rotary printing press.

109. (New) The method of claim 99 including providing at least one roll changer in said web-fed rotary printing press and transmitting roll transport data between said material flow system and said at least one roll changer using at least one fixed signal connection.

110. (New) The method of claim 109 further including providing a management level signal connection between said roll supply system and said product planning system different from said at least one fixed signal connection.

111. (New) The method of claim 109 further including providing a management level signal connection between said roll supply system and said material flow system.

112. (New) The method of claim 99 further including using said production-relevant data in

said material flow system and determining a consumption amount.

113. (New) The method of claim 99 further including storing rolls in said roll storage facility and monitoring said stored rolls in said material flow system.

114. (New) The method of claim 99 further including providing a flow control of said at least first and second subsystems in said roll supply system using said material flow system.

115. (New) The method of claim 99 further including providing transport orders to said at least first and second subsystems of said roll supply system in said material flow system.

116. (New) The method of claim 99 further including providing movement control and storage space management of said at least first and second subsystems of said roll supply system in said material flow system.